

Work Order ID 84938

84938

Page 1

May-29-12 1:11:31 PM

Item ID: D2918-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle LH

Start Date: 29/05/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/30 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2918

Rev B

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

0.00

HAAS I

Memo

HAAS CNC vertical machine #1

Program batch number Machine Step No 1 as per Folio FA441 and visually inspect as per Dwg D2918 & attached Dimension Sheet Machine Step No 2 as per Folio FA441 and visually inspect as per Dwg D2918 & attached Dimension Sheet Machine Step No 3 as per Folio

110

0.00

110

CONVENTIONAL MILLING MACHINE

0.00

Mill Conv

Memo

Conventional Milling Machine

Machine Keyway and inspect per Dwg D2918 & attached dimension sheet

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
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SPC (Y/N):

Date:

Stop ***NR2***

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130 QC8- Inspect parts - second check

0.00

SL 12-06-19

130

QC

Memo

0.00

Quality Control

140 Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

20 24/6 12-6-19

150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3200F

7:40

8:10

20 X 4 12/6/20

M120222

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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

20x p H 12/06/20

170

Identify as per dwg & Stock Location

0.00

170

Packaging

Memo

0.00

Packaging

20x

SP 12/6/20

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/6/20

MLJ 12/06/20

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Picklist Print

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Page 1

Work Order ID: 84938

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Parent Item: D2918-1

D2918-1

Parent Item Name: Saddle LH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP: A04.07.16New IssueKJ/JLM

IPP B 07.08.07 ECN930 EC

verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-011		Manufactured	No			100	Each	66.0000	1	20			

D6102-011

Saddle Billet

**

DA 12/06/13

Location

Loc Qty

Loc Code

MAT043

6

52068

6

MAT047

60



75834

60

20.0

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Inspect dimensions highlighted on inspection sheet drawing and record below:

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	08.02.28	Dimension 'R' revised	KJ/DD	
C	08.11.27	Dimension 'AB, AC' added	KJ/JLM	

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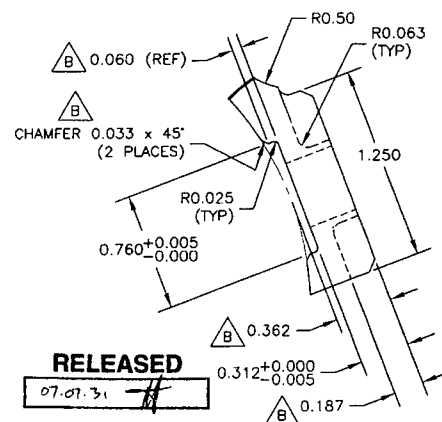
NOTE: Date & initial all entries



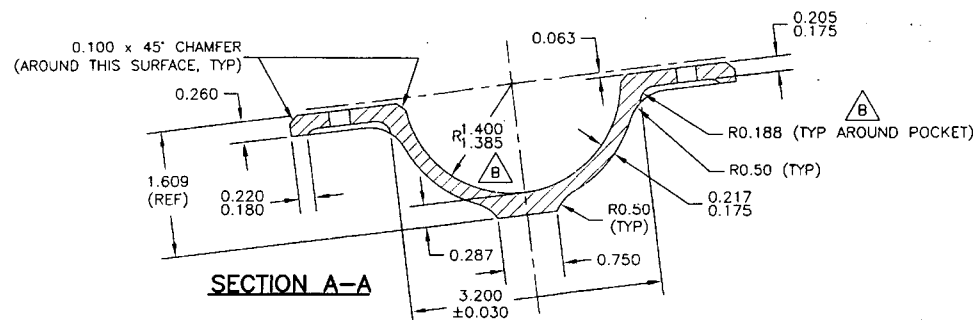
D2918-1 LH SADDLE (SHOWN)
D2918-2 RH SADDLE (OPPOSITE)

NOTES:

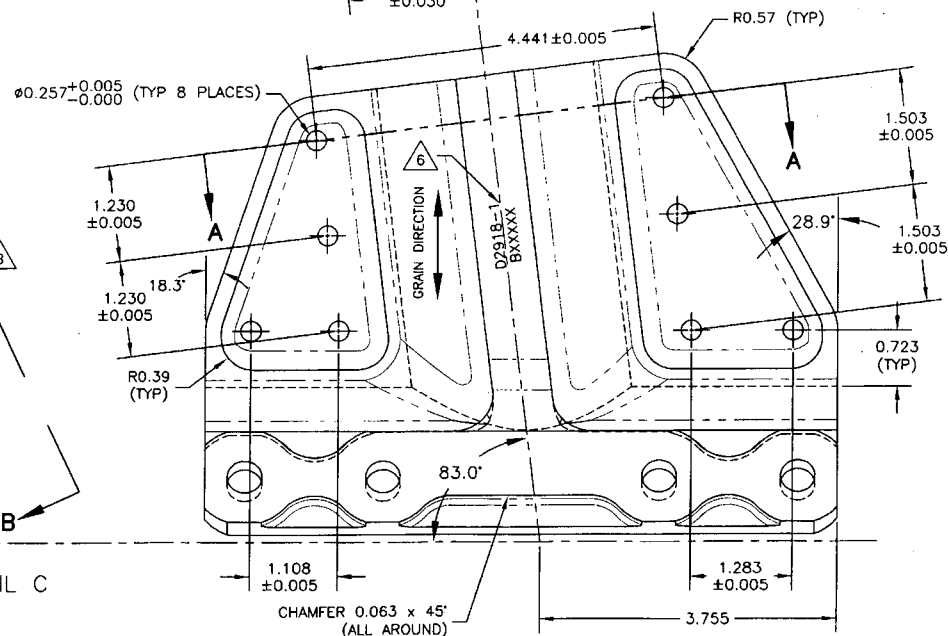
- 1) MATERIAL: ALUMINUM 6061-T6/T651 PER QQ-A-250/11
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
3) BREAK ALL SHARP EDGES 0.010 TO 0.020
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5) ALL DIMENSIONS ARE IN INCHES
6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
7) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125




DETAIL C 
SCALE 4:3



SECTION A-A



B	07.02.19	ADD 0.362, 0.187, 0.060, CHAMFER; ADD DETAIL C; R0.188 WAS R0.30; ADD TOL TO R2.000; ADD NOTES	
A	04.05.31	NEW ISSUE	
DESIGN QP	DRAWN BY CB		DART AEROSPACE LTD. HAMMILLERY, ONTARIO, CANADA
CHECKED PH	APPROVED H	DRAWING NO. D2918	REV. SHEET 1 OF 1
DATE 07.02.19	TITLE SADDLE		SCALE 2:

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 04938 MLJ
12/05/30

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